

4-20-00

A

ASSISTANT COMMISSIONER FOR PATENTS
Washington, D. C. 20231

PATENT APPLICATION
Case Docket No. **199-0287**
Date:

04/19/00
jcs:44
PTB

PTO
jcs:44
09/552710
04/19/00

Transmitted herewith for filing is the patent application of Inventor(s):
Ernest Tong
Dimitar Filev

For: **PORTABLE ADVISORY SYSTEM FOR BALANCING AIRFLOWS IN PAINT BOOTH**

Enclosed are:

- ☒ 2 sheet(s) of drawings
- ☒ Assignment and Cover Sheet
- ☒ Information Disclosure Statement, PTO Form 1449, and Copies of Citations
- ☐ A certified copy of

The filing fee has been calculated as shown below for OTHER THAN A SMALL ENTITY:

<u>FEE</u>	<u>NO. FILED</u>	<u>NO. EXTRA</u>	<u>RATE</u>	<u>FEE</u>
Basic Fee				\$ 690
Total Claims	12	0	18	\$ 0
Indep Claims	2	0	78	\$ 0
Multiple Dependent Claims(s)	0		260	\$ 0
Presented				
			TOTAL	\$ 690

- [X] Please charge Deposit Account No. 06-1510 in the amount shown next to the Total.
A duplicate copy of this sheet is enclosed.
- [X] The Commissioner is hereby authorized to charge payment of the following fees associated with this communication or credit any overpayment to Deposit Account No. 06-1510. If there are insufficient funds in this account, please charge the fees to Deposit Account No. 06-1500. A duplicate copy of this sheet is enclosed.
Any additional filing fees required under 37 CFR 1.16.
Any patent application processing fees under 37 CFR 1.17.
- [X] The Commissioner is hereby authorized to charge payment of the following fees during the pendency of this application or credit any overpayment to Deposit Account No. 06-1510. If there are insufficient funds in this account, please charge the fees to Deposit Account No. 06-1500.
Any patent application processing fees under 37 CFR 1.17.
Any filing fees under 37 CFR 1.16 for presentation of extra claims.

"Express Mail"
Mailing Label Number **EL643673487US**

Date of Deposit 4-19-00

I hereby certify that this paper or fee is being deposited with the United States Postal Service "Express Mail Post Office to Addressee" service under 37 CFR 1.10 on the date indicated above and is addressed to the Commissioner of Patent and Trademarks, Washington, D.C. 20231

1 DR
Damian Porcari
Attorney or Agent of Record
Registration No. 31,461
Ford Global Technologies, Inc.
One Parklane Blvd.,
600 Parklane Towers East
Dearborn, MI 48126

DeAndrea Kirkwood
(Printed Name of Person Mailing Paper or Fee.)

DeAndrea Kirkwood
(Signature of Person Mailing Paper or Fee.)

**PORTABLE ADVISORY SYSTEM FOR BALANCING AIRFLOWS IN PAINT
BOOTH**

5

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates generally to paint
10 booths and, more specifically, to a portable advisory system
for balancing airflows in a paint booth.

2. Description of the Related Art

It is known to provide paint booths for paint
15 applications to motor vehicles. However, in operating the
paint booths, airflow balancing is one of the main issues.
Properly controlled airflow has a significant impact on paint
quality and paint usage through eliminating over-spray between
zones in the paint booth and improving paint transfer
20 efficiency.

One method for balancing the airflows in a paint
booth that is not equipped with a system for automatic control
is based on a trial-and-error approach or procedure. Cross
and down flows in each zone of the paint booth are measured
25 and appropriate adjustments of air supplies such as fans,
variable fan dampers (VFDs) and damper settings are made in
order to obtain some desired distribution of the airflows in
the paint booth. Such an approach requires experience and

good understanding about paint booth dynamics and may be tedious and time consuming.

As a result, it is desirable to provide an advisory system to measure and balance airflows in a paint booth. It is also desirable to provide a low cost system to measure and balance airflows in a paint booth that does not require extra on-line control or sensing. It is further desirable to provide a portable system to measure and balance airflows in a paint booth that is easily transported and used by a single person.

SUMMARY OF THE INVENTION

Accordingly, the present invention is a portable advisory system for balancing airflows in a paint booth. The portable advisory system includes a portable airflow sensor to measure airflows in the paint booth, and a portable computer connected to the airflow sensor for collecting data from the airflow sensor and guiding an operator through a process of adjusting multiple fan speeds and duct dampers to achieve desired airflows.

One advantage of the present invention is that a portable advisory system for balancing airflows in a paint booth is provided. Another advantage of the present invention is that the portable advisory system uses a handheld acoustic anemometer or airflow sensor to measure airflows in a paint booth that are output to a laptop/palmtop computer that

collects data and guides the operator through the process of adjusting multiple fan speeds and duct dampers to achieve the desired airflows in the paint booth in a relatively short time interval without adding costly automation equipment. Yet
5 another advantage of the present invention is that the portable advisory system is a low cost tool for balancing airflows in a paint booth that does not require extra on-line control or sensing equipment. Still another advantage of the present invention is that the portable advisory system
10 eliminates the time consuming, trial and error procedure currently used for balancing airflows in paint booths. A further advantage of the present invention is that the portable advisory system is easily transported and used by a single person. Yet a further advantage of the present
15 invention is that the portable advisory system has automatic data storage and transmittal from an airflow sensor to a computer. Still a further advantage of the present invention is that the portable advisory system automatically updates a simplified model of the airflows in a paint booth and uses
20 this model to iteratively calculate the optimum adjustments to the fan speed and/or duct damper settings by minimizing the mean squared error between current and target airflows.

Other features and advantages of the present invention will be readily appreciated, as the same becomes
25 better understood, after reading the subsequent description taken in conjunction with the accompanying drawings.

BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1 is a diagrammatic view of a paint booth.

FIG. 2 is a block diagram of the paint booth of FIG. 1 illustrated as a multivariable system.

FIG. 3 is a block diagram of a portable advisory system, according to the present invention, for use with the paint booth of FIGS. 1 and 2.

FIG. 4 is a flowchart of a method, according to the present invention, of balancing airflows in the paint booth of FIGS. 1 and 2 with the portable advisory system of FIG. 3.

DESCRIPTION OF THE PREFERRED EMBODIMENT(S)

Referring to the drawings and in particular FIG. 1, one embodiment of a paint booth 10 is shown for painting a vehicle such as a motor vehicle (not shown). The paint booth 10 is represented as a nonlinear multivariable system with zero order dynamics in FIG. 2. The paint booth 10 includes a manual tack-off zone 12, a manual zone 14 adjacent the manual tack-off zone 12 and a robot zone 16 adjacent the manual zone 14. The paint booth 10 also includes a first air system handler 18 for handling airflow into the manual tack-off zone 12 and manual zone 14. The paint booth 10 also includes a damper 20 between the first air system handler 18 and the manual tack-off zone 12. The paint booth 10 also includes a second air system handler 22 for handling airflow into the

robot zone 16 and manual zone 14. The paint booth 10 also includes a damper 24 between the second air system handler 22 and the robot zone 16. The paint booth 10 includes a flash-off zone 26 adjacent the robot zone 16. It should be appreciated that the manual tack-off zone 12 allows an operator to check for defects in the vehicle. It should also be appreciated that the flash-off zone 26 allows paint to settle on the vehicle. It should further be appreciated that the air system handlers 18 and 22 have fans mounted on a roof of the paint booth 10 that blow air from the ceiling to the floor of the zones as known in the art.

The paint booth 10 includes a bells zone 28 adjacent the flash-off zone 26, a basecoat recip zone 30 adjacent the bells zone 28 and a manual zone 32 adjacent the basecoat recip zone 30. The paint booth 10 also includes a third air system handler 34 for handling airflow into the bells zone 28 and the basecoat recip zone 30. The paint booth 10 includes a damper 36 between the third air system handler 34 and the bells zone 28. The paint booth 10 further includes a flash-off zone 38 adjacent the manual zone 32. It should be appreciated that the manual zone 32 allows an operator to manually touch-up the paint of the vehicle. It should also be appreciated that the flash-off zone 38 allows paint to settle on the vehicle. It should further be appreciated that the air system handler 34 has fans mounted on a roof of the paint

booth 10 that blow air from the ceiling to the floor of the zones as known in the art.

The paint booth 10 includes a clearcoat bells zone 40 adjacent the flash-off zone 38. The paint booth 10 also includes a fourth air system handler 42 for handling airflow into the clearcoat bells zone 40. The paint booth 10 also includes a flash-off zone 44 adjacent the clearcoat bells zone 38. It should be appreciated that the flash-off zone 44 allows paint to settle on the vehicle. It should further be appreciated that the air system handler 42 has fans mounted on a roof of the paint booth 10 that blow air from the ceiling to the floor of the zones as known in the art.

The paint booth 10 includes a clearcoat robot zone 46 adjacent the flash-off zone 44, a clearcoat manual zone 48 adjacent the clearcoat robot zone 46 and a paper pull zone 50 adjacent the clearcoat manual zone 48. The paint booth 10 includes an oven tunnel zone 52 adjacent the paper pull zone 50 and an oven zone 54 adjacent the oven tunnel zone 52. The paint booth 10 also includes a fifth air system handler 56 for handling airflow into the clearcoat robot zone 46. The paint booth 10 further includes a sixth air system handler 58 for handling airflow into the clearcoat manual zone 48, paper pull zone 50 and oven tunnel zone 52. It should be appreciated that the air system handlers 56 and 58 have fans mounted on a roof of the paint booth 10 that blow air from the ceiling to the floor of the zones as known in the art. It should also be

appreciated that the paint booth 10 is conventional and known in the art.

Referring to FIG. 2, the paint booth 10 is illustrated as a multivariable system with damper positions and fans VFDs as inputs, vector u , and down and cross velocities as outputs, vector y .

Referring to FIG. 3, a portable advisory system 60, according to the present invention, is shown for use with the paint booth 10. The portable advisory system 60 includes an airflow sensor 62 and a main computer unit 64, both of which are portable. The airflow sensor 62 is portable and has a serial communication interface for communicating with the main computer unit 64. The airflow sensor 62 is of a handheld acoustic anemometer type. The airflow sensor 62 measures the cross and down velocities and communicates the measured data with the main computer unit 64. It should be appreciated that the airflow sensor 62 is conventional and known in the art.

The main computer unit 64 is a portable computer unit such as a laptop or palmtop computer. The main computer unit 64 has a memory, a processor, a display and a user input mechanism, such as a mouse or keyboard, as subsequently described. The main computer unit 64 contains a first database (DB1) 66 of information such as last optimal commands and last optimal sensitivity model to be described. The main computer unit 64 contains a second database (DB2) 68 of information such as air velocities and VFD/damper commands to

be described. The main computer unit 64 also contains an algorithm 70 of a method, according to the present invention to be described, of balancing airflows in the paint booth 10. The algorithm 70 includes a learning instantaneous sensitivity
5 model (J) and on-line optimization to be described. The algorithm 70 communicates with the first and second databases 66 and 68. The main computer unit 64 further includes a flexible set-up dialog 72 that communicates with the algorithm 70.

10 In operation, the portable airflow sensor 62 measures air velocities in the zones of the paint booth 10. After measuring all air velocities that are subject of adjustment, the portable airflow sensor 62 transmits the cross and down velocity data to the second database 68. The
15 measured air velocities and the VFD's/Damper data that are associated with these measured values are passed to the algorithm 70. It should be appreciated that, except for the databases 66 and 68 and algorithm 70, the portable airflow sensor 62 and main computer unit 64 are conventional and known
20 in the art.

Referring to FIG. 4, a flowchart of a method, according to the present invention, of the algorithm 70 is shown. The algorithm 70 updates a sensitivity model (J) of the paint booth 10. The sensitivity model (J) contains
25 estimates of the matrix of the first partial derivatives of the velocities with respect to the VFD's/Dampers (input-output

Jacobian). The Widrow-Hoff rule is used for leaning the Jacobian matrix rather than directly calculating the partial derivatives in order to eliminate the effect of noise. The flexible set-up dialog 72 includes user-friendly software that
 5 configures the portable advisory system 60 so it can be used in different paint booths 10. The first database 66 contains the last update of the sensitivity model (J) and last optimal VFD's and dampers' settings. The second database 68 contains the current VFD's and dampers' settings and the corresponding
 10 cross/down velocities.

After completing each set of velocity measurements, the algorithm 70 calculates a mean squared error (MSE) between the output velocity vector y and the vector of targets y_d . If the MSE is nonzero and a gradient of change of the input
 15 vector u exceeds a threshold constant, the sensitivity model (J) of the paint booth 10 is updated by using the Widrow-Hoff rule:

$$J(k+1) = J(k) + \alpha[\Delta y(k) - J(k)\Delta u(k)]\Delta u^T(k) \quad (1)$$

20

In the above expression, α stands for the rate of learning. This rate varies with an input autocorrelation matrix and opens/closes the sensitivity model (J) for learning based on the changes in the input signal or vector u :

25

$$\alpha = 0.9 * \frac{2}{[\Delta u(k)^T \Delta u(k)]} \quad (2)$$

The optimal change of the inputs or input vector u in direction of minimizing the MSE is calculated at each step by applying a modified version of the Levenberg-Marquardt optimization algorithm with a variable rate ρ :

$$\Delta u(k) = [J^T J + \rho I]^{-1} J^T (y(k) - y_d) \quad (3)$$

10

The variable rate ρ controls the speed and robustness of the Levenberg-Marquardt optimization algorithm. For small ρ , the Levenberg-Marquardt optimization algorithm is fast, but less robust. For higher ρ , it is more robust, but converges slower. In the algorithm 70 of the present invention, the rate ρ is dynamically determined by the gradient of the MSE between the output vector y and the target vector y_d . If the MSE systematically decreases, which is an indication for a robust optimization process, the rate ρ is decreased vice versa. Feasibility of the new input vector update u :

15

20

$$u(k+1) = u(k) + \Delta u(k) \quad (4)$$

25

is checked by comparing with lower and upper limits and the elements that exceed the limits are replaced by the particular limits themselves. The new input values are placed in the second database 68 and displayed. These updated output values
 5 are manually applied as new VFD/damper settings. These new input values are used in the next adjustment of the inputs. The new inputs and the current sensitivity model (J) are stored in the first database 66 for further use. The purpose of the first database 66 is to save the last optimal input
 10 settings and the last sensitivity model (J) for a particular paint booth 10 so they can be used as initial conditions for starting the algorithm 70 every time a new balancing procedure starts.

In the present invention, the method starts in box
 15 100 with the input vector $u(k)$ and output vector $y(k)$. The method advances to block 102 and calculates the sum-squared error (e), between the current outputs and their targets. The method then advances to block 104 and calculates the norm (N) of the change in the measure of the control signal (Δu). The
 20 method advances to diamond 106 and determines whether the norm (N) of Δu is greater than a predetermined parameter (ϵ). If not, the method advances to block 108 and sets a change of control Δu equal to a zero value. The method then advances to block 110 and calculates the new input vector (u) according to
 25 equation (4) previously described. In this case, no change of control is made.

In diamond 106, if the norm of Δu is greater than ϵ , the method advances to block 112 and calculates the rate of learning (α) according to equation (2) previously described. The method advances to diamond 114 and determines whether the
5 change in error (Δe) is systematically less than or equal to zero. If so, the method advances to block 116 and increments parameter ρ . The method then advances to block 118 and calculates the change in the input signal according to equation (3). The method advances to block 110 previously
10 described.

In diamond 114, if the change in error (Δe) is not systematically less than or equal to zero, the method advances to diamond 120 and determines whether the last change in error is greater than a zero value. If not, the method advances to
15 block 118 previously described. If so, the method advances to block 122 and calculates parameter ρ . The method then advances to block 118 previously described.

The present invention has been described in an illustrative manner. It is to be understood that the
20 terminology, which has been used, is intended to be in the nature of words of description rather than of limitation.

Many modifications and variations of the present invention are possible in light of the above teachings. Therefore, within the scope of the appended claims, the
25 present invention may be practiced other than as specifically described.

WHAT IS CLAIMED IS:

1. A portable advisory system for balancing airflows in a paint booth comprising:

5 a portable airflow sensor to measure airflows in the paint booth; and

a portable computer connected to said airflow sensor for collecting data from said airflow sensor and guiding an operator through a process of adjusting multiple fan speeds and duct dampers to achieve desired airflows.

2. A portable advisory system as set forth in claim 1 wherein said computer includes a database of optimal control settings for storing information of last optimal commands and last optimal sensitivity model.

3. A portable advisory system as set forth in claim 1 wherein said computer includes a database for storing information of air velocities and VFD/damper commands.

20

4. A portable advisory system as set forth in claim 1 wherein said computer is a laptop computer.

5. A portable advisory system as set forth in claim 1 wherein said computer is a palmtop computer.

25

6. A portable advisory system as set forth in claim 1 wherein said computer includes a flexible set-up dialog.

5 7. A portable advisory system as set forth in claim 1 wherein said computer includes an algorithm communicating with a plurality of databases and a flexible set-up dialog.

10 8. A method of balancing airflows in a paint booth, said method comprising the steps of:

providing a portable airflow sensor to measure airflows in the paint booth;

15 providing a portable computer and connecting the portable computer to the air flow sensor;

measuring the velocity of the airflows in the paint booth with the airflow sensor and storing the measured airflows in a database; and

20 updating a sensitivity model (J) of the paint booth with the measured velocity of the airflows to balance the airflows in the paint booth.

9. A method as set forth in claim 8 including the step of updating on-line the VFD and damper settings.

10. A method as set forth in claim 8 wherein said step of updating includes computing a mean squared error with the sensitivity model (J).

5 11. A method as set forth in claim 8 including the step of updating new inputs and current sensitivity model in a first database.

10 11. A method as set forth in claim 8 including the step of calculating a rate of learning.

PORTABLE ADVISORY SYSTEM FOR BALANCING AIRFLOWS IN PAINT
BOOTH

5

ABSTRACT OF THE DISCLOSURE

10 A portable advisory system for balancing airflows in
a paint booth includes a portable airflow sensor to measure
airflows in the paint booth, and a portable computer connected
to the airflow sensor for collecting data from the airflow
sensor and guiding an operator through a process of adjusting
multiple fan speeds and duct dampers to achieve desired
airflows.

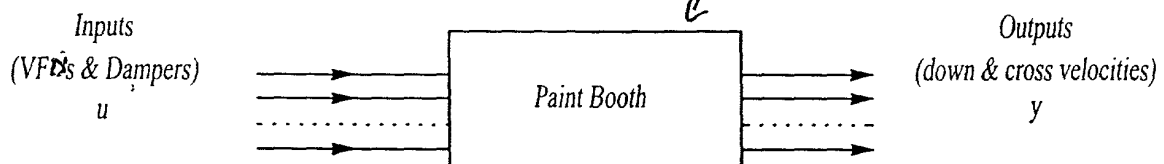
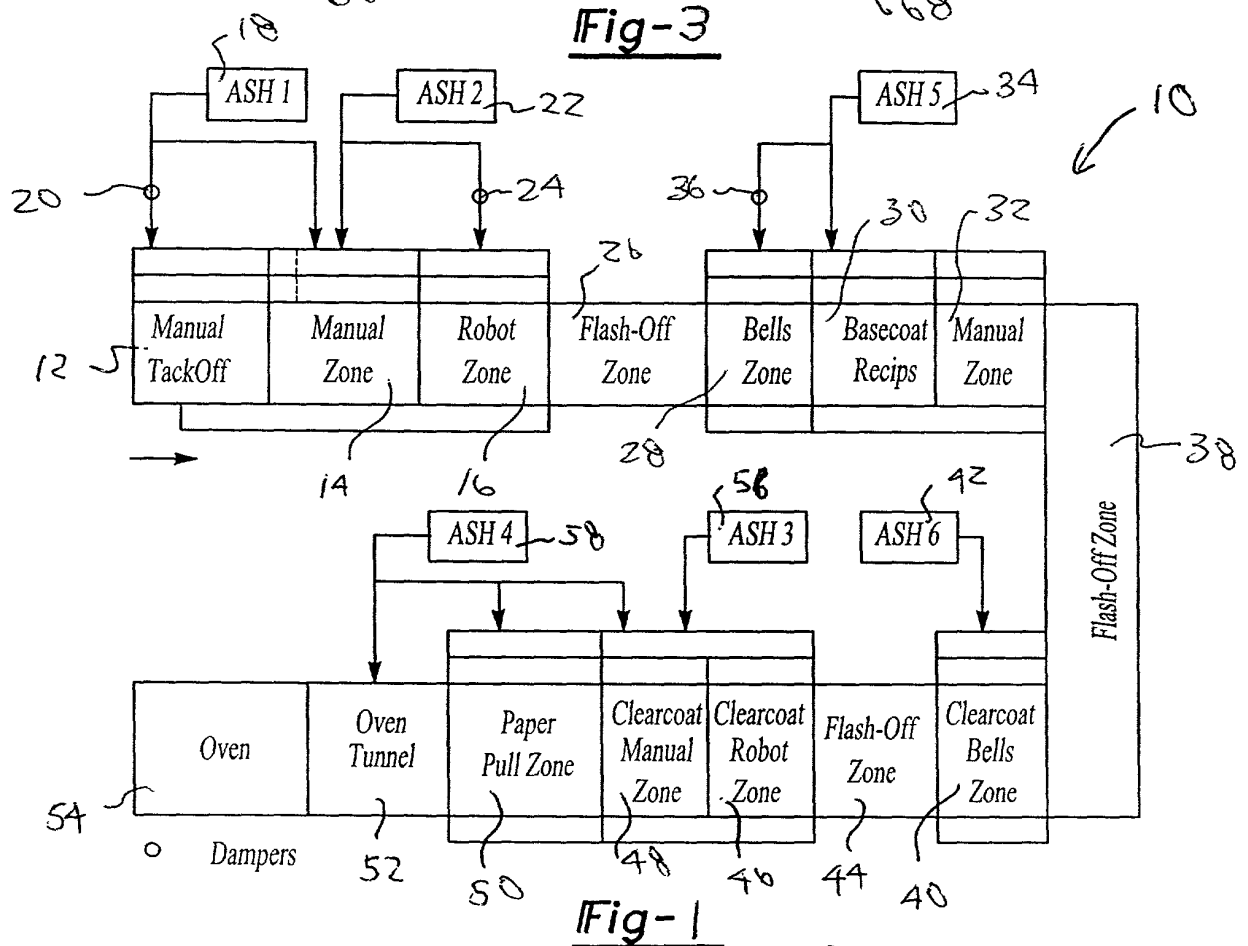
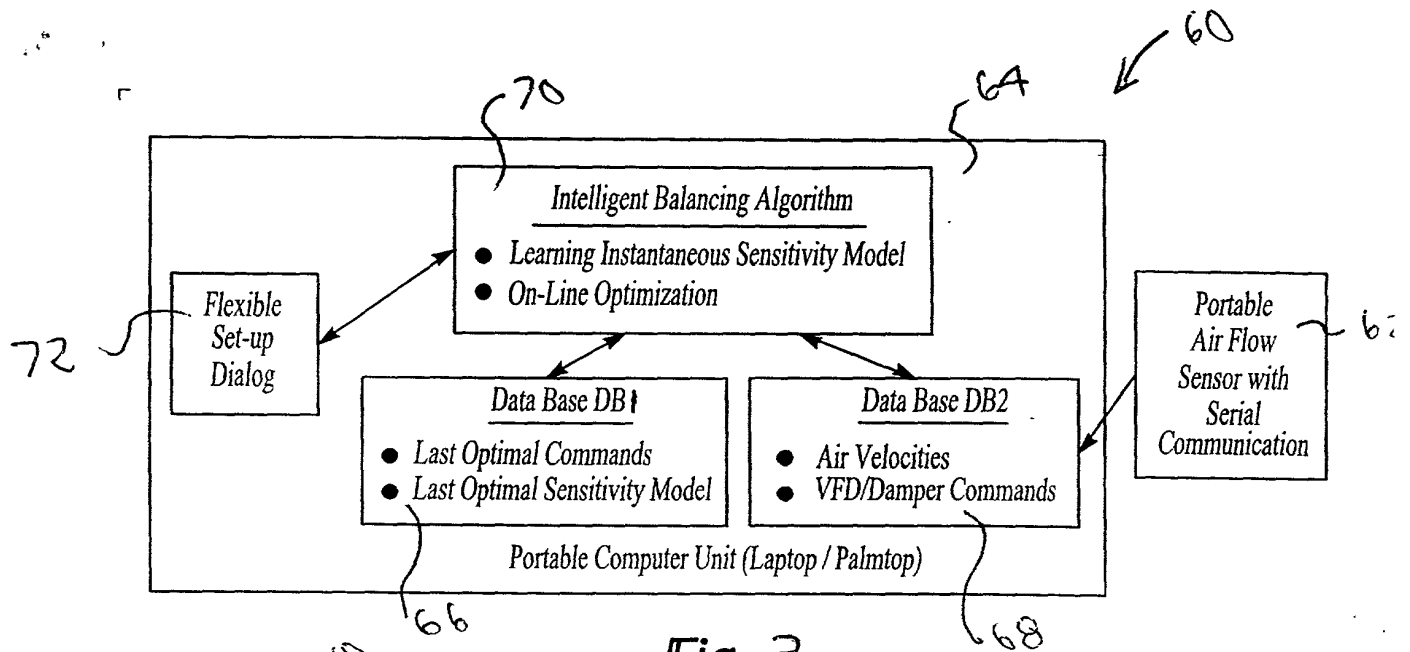


Fig-2

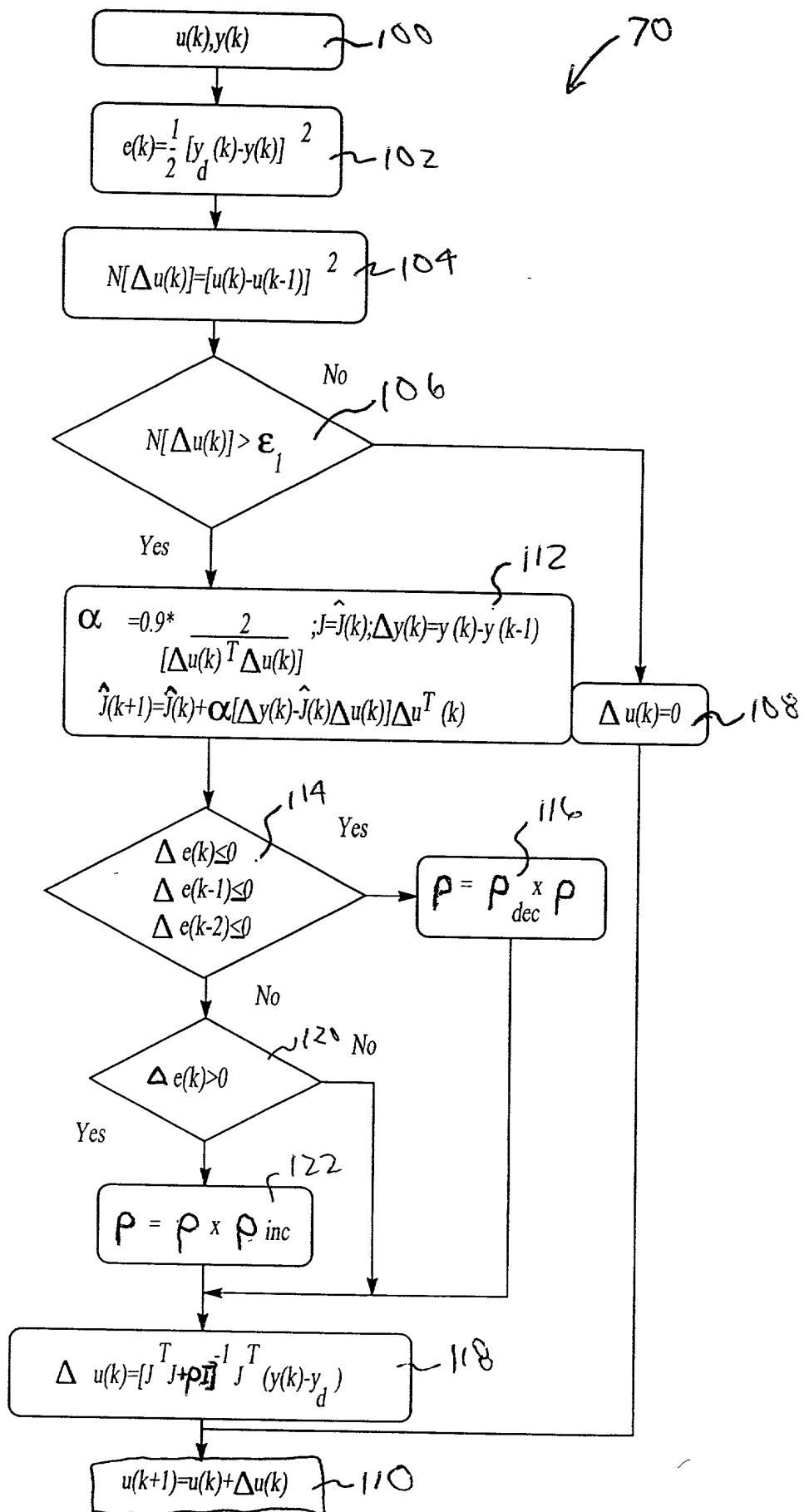


Fig-4

DECLARATION AND POWER OF ATTORNEY - ORIGINAL APPLICATION**Attorney's Docket No.
199-0287**

As a below named inventor, I hereby declare:

My residence, post office address and citizenship are as stated below next to my name;

I verily believe I am the original, first and sole inventor or an original, first and joint inventor of the subject matter that is claimed and for which a patent is sought on the invention entitled

PORTABLE ADVISORY SYSTEM FOR BALANCING AIRFLOWS IN PAINT BOOTH

the specification of which is attached hereto.

I have reviewed and understand the contents of the specification identified above, including the claims.

I acknowledge my duty to disclose information of which I am aware that is material to the examination of this application in accordance with Section 1.56(a), Title 37 of the Code of Federal Regulations; and

as to application for patents or inventor's certificate on the invention filed in any country foreign to the United States of America, prior to this application by me or my legal representatives or assigns,

☒ no such applications have been filed, or

☐ such applications have been filed as follows

COUNTRY	APPLICATION NO.	DATE OF FILING (day, month, year)	DATE OF ISSUE (day, month, year)	PRIORITY CLAIMED UNDER 35 USC 119

I hereby claim the benefit under 35 U.S.C. § 120 of any United States application(s) or § 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. § 112, I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR § 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of this application.

(Application Number) (Filing Date) (Status - patented, pending, abandoned)

(Application Number) (Filing Date) (Status - patented, pending, abandoned)

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the United States Patent and Trademark Office connected therewith and to act on my behalf before the competent International Authorities in connection with any and all international applications filed by me.
(List name and registration number)

Daniel H. Bliss - 32,398

Damian Porcari - 31,461

Roger L. May - 26,406

Address all correspondence and telephone calls to:

Daniel H. Bliss
Bliss McGlynn P.C.
2075 West Big Beaver Road Suite 600
Troy, MI 48064 Phone: 248 - 649-6090

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

NAME AND POST OFFICE ADDRESS OF INVENTOR:	RESIDENCE	CITIZENSHIP	SIGNATURE	DATE
Dimitar P. Filev 23280 Mystic Forest Drive Novi, MI 48375 US	Novi, MI 48375 US	Bulgaria	<i>D. Filev</i>	4/5/00
Ernest Henry Tong 44720 Patrick Dr Canton MI 48187	Canton MI 48187	U.S.A	<i>E. Tong</i>	4/10/00